Reject KSP Work Center ID Description Code Qty Qty Number **Run Hours Draw Nbr Revision Nbr** 

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W/O:		WORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE	By Date Qty	Approval Chief Eng / Prod Mgr  Approval QC Inspector				

Part No: _		_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
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•	Resolution:		Disposition:	QA: N/C Closed	<b>i</b> :	Date:	:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
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4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. \*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAP		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Cate	jory:	_ NCR	: Yes	No DQA		Date:		
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DATE	0750	Description of NC	Corrective Action Sect				Verific	ation	Approval	Approval	
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Work Order ID 79852  February-06-12 11:11:34 AM				*798	352*							Page 3	
Item ID: Revision ID: Item Name:	D350-636-0	12		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*N: *N:	S1* S2*	_
Start Date: Required Date: Reference:	06/02/2012 20/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Da	te:			Run	Start Stop	*N  *N	R1* R2*	
Sequence ID/ Work Center II		from bendir A/R Alum	2744 Cap as per Dwg E gg as per QSI 004 inum Rod batch: elds flush as per Dwg I		Tool ID  es in bend left  26 2/03/15  -3 -16	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
*170* QC Quality Control	-	QC10- Inspect visual per	r QSI004- ground weld	s 0.00 PC 15	2.03.19			_/x	J.	Y			
130 *130* QC		QC5- Inspect part compl	eteness to step on W/C	0.00				_m/_	1	12:	3	-19 G	ı

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W/O:			WORK ORDER CHANGES									
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Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _					
	Re	esolution:	_ Disposit	ion:	_ QA: N/C Cld	sed:	Date: _					
NCR:		W	ORK OR	DER NON-CONFORM	ANCE (NCR	)						
DATE	STEP	Description of NC			tion B	Verification	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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Work Ord February-06-12			*79852*								Page 4
Item ID: Revision ID: Item Name:	D350-636-0	12		Accept	*N900	<b>040</b>	100	)* s	etup Sta	171	S1* S2*
Start Date: Required Date: Reference:	06/02/2012 20/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					.7/
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:	 	R	un Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		Chemical Conversion Co	at per QS1005 4.1	0.00				~ 1/2		~ ~	0
*140* HandFinish Hand Finishing		Memo		0.00				467		12-3-	19

150

QC3- Inspect Part Finish

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Quality Control

Memo

0.00

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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	·	PAR #:	Fault Cat	egory:	_ NCR	Yes I	No DQA	<b>\</b> :	Date:	· · · · · · · · · · · · · · · · · · ·				
	Resolution:			on:	QA:	N/C Clo	sed:		Date: _					
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		Description of NC	otion of NC Corrective Action				Verific	ation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector				
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Work Ord February-06-12			, b., m	*79	9852*						Page 5		
Item ID: Revision ID: Item Name: Start Date:	D350-636-01 Skidtube RH 06/02/2012	12 Start Qty: 1.00	:	Accept	*N900 Cust Item I		100	)*	Setup Sta	1 1	S1* S2*		
Required Date: Reference:	20/02/2012	Req'd Qty: 1.00	4	*1*	Customer:	2.							
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ite:			Run Sta Sto	17	R1*		
	QC:		Date:	SPC (Y/N):	Da	ite:			300	* *N	R2*		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hou 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
*160* Skidtubes				, 0.00 L and ground handling to 0.62:	5" (total of 8 holes per						·		
		as per dwg [	oles of Detail K	C to 0.750" (total of 4 holes per (4 per Side)	side)		\		, 1		·		
		(welding ins	tructions on she		holes per dwg D2750		E	131	2/03/1	9			
				hips from inside of tube remove alodine as required.									
	•	7-Bond web	D2739 in place	e as per QSI 015 batch: 1208/3 exp. date: 12/08/3	3 3 (2	f03/19	<b>?</b>						
	7	(welding inst	eers D3490-1, E tructions on she um Rod bate		3 D2750 & QS1004 BE 12/3/20	<b>)</b>							
		9- At section	AP-AP drill ou	ut x-bolt spacer to 0.404"	BE 12/03/20	21							
		10-Grind we	lds flush as per	Dwg D2750	> CF 12.3	حد ۱ ا	1 . 1	()					
		11-Spot face	ground handlir	ng holes section (total of 4 pla	ces per side) as per	D 12	-103/	21					

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W/O:	<u> </u>	WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHAI		В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	•	PAR #:	Fault Cated	jory:	NCR: `	res N	lo <b>DQ</b>	A:	Date:					
	Re	solution:	Disposition	1:	QA: N/	C Clo	sed:	1888, e. c	Date: _					
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (N	(CR)	-							
		Description of NC			tion B		Verific	cation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date			Chief Eng	QC inspector				
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	<b>Vork Order ID 79852</b> bebruary-06-12 11:11:34 AM			*798	352*					Page 6
Item ID: Revision ID:	D350-636-0	12		Accept	*N900	<b>04010</b>	)*	Setup Star	1 7	S1*
Item Name:	Skidtube RH		ata da ata					Stop	• *N	S2*
Start Date: Required Date Reference:	06/02/2012 :: 20/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:	I	Run Star	!/	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:		Stop	' *N	R2*
Sequence ID/ Work Center I	D	Operation Description dwg D2750 12-Deburr h	oles	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control		QC10- Inspect visual per	QS1004- ground welds	0.00 5/2/0	3/22					
*180 *180*		QC5- Inspect part compl  Memo	eteness to step on W/O	0.00	1/3/23					

Quality Control

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Part No		PAR #:	Fault Cat	egory:	NCR	Yes 1	lo <b>DQA</b>	:	_ Date: _	
	R	esolution:	Dispositi	on:	QA: 1	N/C Clo	sed:		Date:	
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DATE	STEP	Description of NC			Section B		Verifica		Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Descriptio	n	Sign & Date	Sectio	n C	Chief Eng	QC Inspector

- Work Order ID 79852 \*79852\* Page 7 February-06-12 11:11:34 AM Item ID: D350-636-012 Accept \*N900040100\* Setup Start **Revision ID:** Skidtube RH Item Name: 06/02/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date: 20/02/2012** Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: **Approvals: Tooling:** Date: QC: Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 190 Pressure Wash per QSI005 4.3 0.00 \*190\* HandFinish 0.00 Memo Hand Finishing Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch. 200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 \*200\* Powdercoat 0.00 Memo START TIME: 7/25 Powder Coating OVEN TEMPERATURE: FINISH TIME: 7455

0.00

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QC

Quality Control

QC3- Inspect Part Finish

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Inspect for foreign object per QSI 024

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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQA</b> :	Date: _	
	Re	esolution:	Dispositio	າ:	QA: N/C Cld	sed:	Date: _	
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DATE	OTED	Description of NC			ction B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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<b>Work Orde</b> February-06-12				*798	352*							Page 8	
Item ID: Revision ID: Item Name:	D350-636-01 Skidtube RH			Accept	*N900	<u>)</u> 040	100	<b>*</b> s	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date: Reference:	06/02/2012 20/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:								
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		eate:		R		Start Stop		R1* R2*	
Sequence ID/ Work Center II 230 *230* HandFinish Hand Finishing	)	2-Inspect for 3-Spray insibatch:	erts as per dwg D2750  Foreign Objects  de of tube with "LPS-3"	Set Up/ Run Hours 0.00  0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Rumber	Insp. Stamp	3
		per dwg D27 SIKA FLEX BATCH: EXP DATE: 5-assemble of A/R 55-o'rin	12108	3\8 3 3492 and apply o'ring lub				,	4		JU	(d 64	16

W/O:			WC	ORK ORDER CHANGI	ES				
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Part No		PAR #:			NCR: Yes	No <b>DQ</b>	A:	Date: _	
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NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCF	1)			
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
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Work Orde February-06-12				*798	352*				-			Page 9	
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube RH	12		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	06/02/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:							
Approvals:	Process Pla	in:	Date:	Tooling:	Da	te:			Run	Start	*N	R1*	
	QC:		Date:	_ SPC (Y/N):	Da	te:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
* <b>?</b> 40 * <b>?</b> 40* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00	vu\us							;	
250 *250* Packaging Packaging		Pick Kit Memo		0.00			1	×	S	) 10	1-0Y	-07 -	
<sup>260</sup> *260*		QC4- 100% Inspect kits	for completeness	0.00	مان								
QC		Memo		0.00	cuo7							-	

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Part No	<b>:</b>	PAR #:	Fault Cat	tegory:	_ <b>NCR:</b> Yes 1	lo DQA:	Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Item ID: D350-636-012	4													
Revision ID:   Item Name:   Skidtube RH   Stop   *N\$1   *N\$1   *N\$2   * N\$2   * N\$2   * N\$3   * N\$3						*798	352*							Page 1
Start Date:   O6/02/2012   Start Qty:   1.00   *1 *   Cust Item ID:   Customer:		D350-636-0	012			Accept	*N900	040	100	)*	Setup	Start	*N	S1*
Start Date: 06/02/2012   Start Qty: 1.00		Skidtube RH										Stop	*N	S2*
Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N): Date: Sequence ID/ Description Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Number Stamp 0.00  *270 *270 *270 *270 *270 *270 *270 *	Required Dat		- 0		•			ID:						
Sequence ID/ Work Center ID  Description  Run Hours  Packaging  Memo  Set Up/ Run Hours  Set Up/ Run Hours  Set Up/ Run Hours  Tool ID  Tool # Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp  **NR2**		Process Pl	an:	Date:		Tooling:	D:	ate:	_		Run		*N	R1*
Work Center ID Description Run Hours Code Qty Qty Number Stamp  270  *270  Packaging  Memo  0.00		QC:		_ Date:_		SPC (Y/N):	D	ate:				Stop	*N	R2*
*270* Packaging  Memo  0.00	Work Center		-			Run Hours	Tool ID	Tool #				-		-
Packaging Package as ner PPP D350.636.012	*270*		Memo							<i>E</i>	0	12/	T & 1	

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QC21- Final Inspection - Work Order Release

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Quality Control

Page 10

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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
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#### **Picklist Print** .- February-06-12 11:11:38 AM \*79852\* Work Order ID: 79852 Parent Item: D350-636-012 \*D350-636-012\* Parent Item Name: Skidtube RH **Start Date:** 06/02/2012 Start Qty: 1.00 Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ As per Rev D IPP Rev:J 06-03-29 EC IPP Rev:K 06-07.13 As per dsi9343 EC IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per IIN revH DD verf:EC Component Item ID/ Primary Replacement Mfg/ Rin Last Route Unit of Oty on Oty per Kit Total

Item Name	Item ID	Purch	Item	Location	Last	Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	12.0000	1	1			
*D2600-3-	RFNT*			B	8/330	- *			**	0	XI	かか	3-14
				Locatio	<u>n</u>	Loc	Oty	Loc Code					
				LG			12		_	***			
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D2744		Manufactured	No			110	Each	20.0000	1	1 .			
*D2744*									**			BE 12	1-03-15
				Locatio	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				LG002			20				_		
					62715		1		_				
					70881		12		_		_		
					71861		7		_		_		

**Required Date: 20/02/2012** 

Required Qty: 1.00

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:		_ Date: _	
	Re	solution:	Disposition	:	QA: N/C Clo	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)	-	.,	
		Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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· February-06-12 11:11:38 AM Work Order ID: 79852 \*79852\* Parent Item: D350-636-012 \*D350-636-012\* Parent Item Name: Skidtube RH Start Date: 06/02/2012 **Required Date: 20/02/2012** Start Qty: 1.00 Required Qty: 1.00 D2739 Manufactured No 160 Each 4.0000 \*\* 350 I Beam Location Loc Qty Loc Code LG 72155 78898 3 D2743 160 Manufactured No Each 172.0000 \*D2743\* \*\* BE12/03/20 Crossbolt Spacer Location Loc Qty Loc Code LG001 172 67766 68251 3 73403 64 74445 2 78603 99 D3490-3 Manufactured No 160 46.0000 Each \*D3490-3\* \*\* BE12/03/20 Cross Bolt Spacer Location Loc Qty Loc Code

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W/O:			W	ORK ORDER CHANG	ES				
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DATE	STEP	Description of NC		Corrective Action Section		,	Verification	Approval	Approval
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**Shop Packet Print** 

Page 3

February-06-12 11:11:38 AM

W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector						
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQ	<b>A</b> :	_ Date: _							
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NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NCR	)									
		Description of NC		Corrective Action Section	Verific	ation	Approval	Approval							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector						
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Picklist Print February-06-12 11:11:38 AM						Page 4
Work Order ID: 79852		*7	9852*			·
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			350-636-01	12*	Start Date: 06/0 Start Qty: 1.00	•
MS21043-6 *MS21043-6* NUT	Purchased	No		230 Each	833.0000 4 **	M/L 12/04/03
			Location FG 103693 ST301 112314 117887 118384 120308	20 20 813 103 10 200 500	Loc Code	
D3794-1 *D3794-1* Gasket	Manufactured	No	<u>Location</u>	230 Each	16.0000 1 <b>**</b>	m.f. 12/04/03
			FP002 75042	<u>Loc Qty</u> 16 16	Loc Code	
*NAS1611-010 *NAS1611-010* O-RING	Purchased	No		230 Each	149.0000 8 **	8 M. L 12/04/03
			Location  FP  110915 120121  FP001  110915 117460 118077 118612 119438	Loc Oty  26  0  26  123  14  8  1  3  47	Loc Code 121166 -	<u>\$</u>
			120308	50	_	<del> </del>

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector					
								F100 Mg/						
_														
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	<del>-</del>					
Reso		esolution:	Dispositi	on:	QA: N/C C	Date: _								
		V	ORK ORE	DER NON-CONFORM	ANCE (NC	R)								
DATE	STEP	Description of NC			ion B Verification			Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector					
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Picklist Print									Page 5
February-06-12 11:11:38 AM									
Work Order ID: 79852		*798!	52*						
Parent Item: D350-636-012			0-636-0	<b>ገ</b> 12*					
Parent Item Name: Skidtube RH		1 7. 1. 1	( )-( ). )( )-(	, , ,		S	tart Date: 06/02	Required Date: 20	0/02/2012
							Start Qty: 1.00	Required Qty: 1.	
D2741	Manufactured	No		250	Each	3.0000		1	
*D2741* Blade, 350 Skidtube							**	B76984	Sp /
		Loc	<u>ation</u>	<u>L</u> e	oc Oty	Loc Code		7)	-04-07
		ST			-10				•
		ST4	66		13				
			71856		3				
NAS1515H3L	Purchased	No		230	Each	236.0000	4	4	
*NAS1515H3I *							**	m. 1. 12/04	03
		Loc	ation	<u>L</u> c	oc Qty	Loc Code	٠,	11/1/10/11	03
		FG			40				
			102472		40			!	
		ST2	77		196				
			118686		3				
			119438	,	5		— <i>—</i>	<del>                                     </del>	
			120072 <b>\</b> 120360		88 100			7	
NAS1611-013	Purchased	No	120300	230	Each	158.0000	8	8	
	1 drenased			250	Luvii	150.0000			\ /
*NAS1611-013*							** \\\ <u>\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\</u>	21166 (x g)	Moyloc
			ation	<u>Lc</u>	oc Qty	Loc Code			
		FP			12				
			117291 120121		0 12				
		FP00			146		-	<del></del>	
		1.100	116582		5				
			117291		2				
			117887		53				
			119623		36				
			120360		50				

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DATE	STEP	PRO	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector				
								1100 Wigi				
	<u>.</u>											
Part No	•	PAR #:	Fault Cate		NCR: Yes	No <b>DQ</b>	A:	Date: _				
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DATE	STEP	Description of NC		ion B		fication	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector			
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Part No	•	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	lo <b>DQ</b>	A:	_ Date: _		
	R	esolution:	Disposition	:	_ QA: N	/C Clo	sed:	. <u></u>	Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (	NCR)					
	STED Description of NC		Corrective Action Section				Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector	
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Picklist Print . February-06-12 11:11:39 AM							Page 7
Work Order ID: 79852		*70	852*			<del></del>	
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			850-636-01	12*	Start Date: Start Qty:		Required Date: 20/02/2012 Required Qty: 1.00
D3794-3 *D3794-3* Gasket	Manufactured	No	Location	230 Each	13.0000 1 **  Loc Code	1 	12/04/03
			74530 74596 78895	13 2 1 10	80436		- 
*AN3C5A *AN3C5A*	Purchased	No		230 Each	1,370.000 34	34 M.L.	12/10/03
D3537-1	Manufactured		Location  FP001  115835  ST350  116419  117343  117764  117872  119127  119749  120423	Loc Oty  7  7  1363  28  13  7  2  280  33  1000  230  Each	<u>Loc Code</u> 51.0000 3	34	
*D3537-1* Wearpad			<u>Location</u> FP002 69817 77560 78591	Loc Oty 51 5 6 40	** Loc Code 79835	m.f	12/04/03

		— - <del></del>						•		•
W/O:			W	ORK ORDER CHANG	ES					,
DATE	STEP	PRO	OCEDURE CH	ANGE	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector
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			<del></del>					<u> </u>		
Part No	*	PAR #:	Fault Cate	egory:	_ NCR:	Yes 1	10 <b>DQ</b>	A:	_ Date: _	
Reso		esolution:	Disposition	on:	_ QA: N	VC Clo	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE (	NCR)	)			
		Description of NC	cription of NC Corrective Action			<u> </u>			Approval	Approval
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	,	Sign & Date			Chief Eng	QC Inspector
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Picklist Print February-06-12 11:11:	39 AM			,						Page 8
	636-012 idtube RH			9852* 350-636-	N12*			art Date:	06/02/2012 1.00	Required Date: 20/02/2012 Required Qty: 1.00
D3535-25 *D3535-25 Wearshoe	*	Manufactured	No		230	Each	14.0000	1 <b>**</b>	1 -M -	1-12/04/03
,				Location FP001 62233 75040 FP002 77617	<u>Lo</u>	2 1 1 12 12	<u>Loc Code</u> 33 [			- - - -
D3492-3 *\int 3492-3* Plug		Manufactured	No	,,,,,,	230	Each	25.0000	8 <b>**</b>	8 Jul 10	alog X
				Location FP002 77039	<u>Loc</u>	25 25	Loc Code 13 8/9	67	X 0	- -
AN960C10L	NAS1149C0332 R	Purchased	No		230	Each	0.0000	38	38	
*AN960C1	NI *				1216	165	· >	**	38	M.f. 12/04/0
D3488-042  *\(\begin{align*} \begin{align*}	2*	Manufactured	No	<u>Location</u>	230 <u>Loc</u>	Each	20.0000 <u>Loc Code</u>	1 **	m.f	12/04/03
				FP002 62003 71883	,	20 1 1				- - -

W/O:			W	ORK ORDER CHANG	ES			<del></del>	
DATE	STEP	PRO	Ву	С	ate Qty	Approval Chief Eng /	Approvál QC Inspector		
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			· · · · · · · · · · · · · · · · · · ·			<del> </del>			
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No	DQA:	Date: _	
	Re	esolution:	Dispositio	on:	QA: N/C	Close	ed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)	,		
		Description of NC	Corrective Action Section B				Verification	Approval	Approval
DATE	STEP Section A		Initial Chief Eng	Action Description Chief Eng	Sigi Da	1 &	Section C	Chief Eng	QC Inspector
l									

#### **Picklist Print** Page 9 February-06-12 11:11:39 AM Work Order ID: 79852 \*79852\* D350-636-012 \*D350-636-012\* Parent Item: Parent Item Name: Skidtube RH **Required Date: 20/02/2012 Start Date:** 06/02/2012 Start Qty: 1.00 Required Oty: 1.00 ALS4-1032-225 Purchased No 230 860.0000 Each 38 38 \*ALS4-1032-225\* \*\* Location Loc Qty Loc Code ST281 369 108696 146 110768 62 93 118386 118966 68 ST282 491 120410 200 120451 291 D3492-1 230 Manufactured No Each 170.0000 \*D3492-1\* \*\* Plug Location Loc Qty Loc Code FP002 170 69531 8 74444 2 76235 60 77037 100 D3793-1 Manufactured No 230 22.0000 Each \*D3793-1\* \*\* Wearshoe Location Loc Qty Loc Code FP001 22 75038 77029 9 78901 12

W/O:	<u> </u>		WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approvat QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
Res		solution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	1)			
		Description of NC		tion B	Verific	cation	Approval Chief Eng	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Section C		QC Inspector	
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Picklist Print February-06-12 11:11:39 AM								Page 10
Work Order ID: 79852		*798	352*				· · · · · · · · · · · · · · · · · · ·	
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			50-636-01	12*		Start Date: Start Qty:		Required Date: 20/02/2012 Required Qty: 1.00
AN8C35A	Purchased	No		230 Eac	h 70.0000	1	1	
*AN8C35A*						**	M-,	1 12/04/43
			<u>cocation</u>	Loc Qty	Loc Code	2	•	,
		F	P002	69				-
			115960 117834	1 12				_
			118286	56				_
		S	T346	1				
			114442	0				<u> </u>
			115188 115960	0				
MS21083C8	Purchased	No	113900	230 Eacl	h 51.0000	i	1	_
*MS21083C8*	Turchased	110		230 Each	31.0000	**	mA	12/04/03
		<u>I</u>	ocation	Loc Oty	Loc Code	2	•	
		F	P002	1				<u> </u>
			115884	1				<u> </u>
		S	T303 115884	18				_
			118077	0				
			119309	2				<del></del>
			119436	13			<del></del>	_
	•	0	119638	2				_
		S	T304 120142	32 32				_
			120112	32				_

W/O:			W	ORK ORDER CHANG	ES				,
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	s No D	QA:	Date: _	
		esolution:							
NCR:		,	WORK ORE	DER NON-CONFORMA	ANCE (NO	R)			
		Description of NC	intion of NC Corrective Action			ection B Verif			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	1&   <sub>S</sub>	ection C	Approval Chief Eng	QC Inspector
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Parent Item Name: Skidtube RH

Page 11

Work Order ID: 79852

\*79852\*

Location

Parent Item:

D350-636-012

\*D350-636-012\*

Start Date: 06/02/2012

**Required Date: 20/02/2012** 

Start Qty: 1.00

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\*\*

\*\*

Required Oty: 1.00

D2745

\*D2745\*

Bushing

Manufactured No 230

Each

Loc Oty

Loc Qty

81

71

35

Each

Each

81.0000

Loc Code

AN6C44A

\*AN6C44A\* **BOLT** 

Purchased

Manufactured

No

FP001 69529 76142 78597

230

250

79518 86.0000

Loc Code

0.0000

Location FG ST343

No

103964 119125 120095 120143 120465

2 2 20 25

D3532-1\* Spacer

D3532-1

W/O:			WC	RK ORDER CHANG	GES				•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						e-Loranza -			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	ution: Disposition: Q					Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCF	<b>?</b> )			
DATE	OTED	Description of NC	ription of NC Section A Corrective Action Section Section A			Verifi	cation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Sign 8 Date	Section C		QC Inspector		
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Picklist Print February-06-12 11:11:39 AM									Page 12
Work Order ID: 79852		*7	9852*						
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			350-636-0	)12*			tart Date: Start Qty:	06/02/2012 1.00	Required Date: 20/02/2012 Required Qty: 1.00
*M\$21083C8 *M\$21083C8*	Purchased	No		250	Each	51.0000	2 **	2 M)	207318
			Location FP002 115884 ST303 115884 118077 119309 119436	<u>L</u> .	1 1 18 0 1 2 2 13	Loc Code			- - - - -
NAS1149D0863J	Purchased	No	119436 119638 ST304 120142	250	13 2 32 32 Each	239.0000	2		- - - -
>*NAS1149D0863	.1*		<u>Location</u>	1.	e Oty	Loc Code	**	<del>-</del> \$	
			ST298 118078 119307 120308	<u> </u>	239 39 100 100	<u>Loc Code</u>		->x	- - -
D3493-1 *D3493-1* Washer	Manufactured	No		250	Each	32.0000	<b>**</b>	2 - SP	12-04-09 6
			Location ST050 70697 72573	<u>Lo</u>	32 2 30	Loc Code		21	- - -

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W/O:			WC	RK ORDER CHANG	GES					•			
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
********													
Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No <b>DQ</b> /	<b>A</b> :	_ Date: _				
Re		esolution:	Disposition: QA				A: N/C Closed: Date:						
NCR:		1	WORK ORDI	R NON-CONFORM	IANCE	(NCR	)						
		Description of NC Corrective Action			Section B			ation	Approval	Approval			
DATE	STEP	Section A	Initial Action Descri Chief Eng Chief Eng		ion Sign & Date		Section C		Chief Eng	QC Inspector			
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#### **Picklist Print**

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Page 13

Work Order ID: 79852

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

\*79852\*

\*D350-636-012\*

**Start Date:** 06/02/2012

**Required Date: 20/02/2012** 

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

53.0000

<u>Location</u>	Loc Oty	Loc Code	
ST343	53		
118758	5		
120094	48		$\mathcal{A}^{\chi}$



N/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								<del>                                     </del>	Prod Mgr	, , , , , , , , , , , , , , , , , , ,		
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR:	Yes N	o <b>DQ</b>	A:	_ Date: _			
	R	esolution:	Disposition	on:	_ QA: N	C Clos	sed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (I	VCR)						
	Description of NC			Corrective Action Section			Verifi	cation	Approval	Approval		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspector		

QTY -041 QTY -042 QTY QTY -043 -044 PART NUMBER DESCRIPTION 350 SKIDTUBE ASSEMBLY, LH X D2750-041 D2750-042 350 SKIDTUBE ASSEMBLY, RH D2750-043 350 SKIDTUBE ASSEMBLY, LH х D2750-044 350 SKIDTUBE ASSEMBLY, RH D2739 WEB 8 8 D2743 8 8 SPACER 1 D2744 CAP 8 D2745 8 8 8 BUSHING D2750-1 SKIDTUBE WELDMENT, LH D2750-2 SKIDTUBE WELDMENT, RH SKIDTUBE WELDMENT, LH D2750-3 D2750-4 SKIDTUBE WELDMENT, RH 1 D3488-041 BLADE FITTING, LH D3488-Q42 BLADE FITTING, RH 4 D3490-1 SPACER 4 4 4 4 D3490-3 SPACER 4 4 D3490-5 SPACER 8 D3492-04 PLUG ASSEMBLY PLUG ASSEMBLY 8 8 D3492-043 D3492-045 PLUG ASSEMBLY 1 D3535-25 1 1 1 WEARSHOE 1 D3536-25 GASKET 1 3 3 D3537-1 WEARPAD 3 3 D3631-1 WASHER 8 8 8 D3791-1 1 WEARPLATE 1 D3793-1 WEARSHOE 1 1 1 D3793-3 WEARSHOE 1 D3794-1 GASKET 1 1 1 D3794-3 GASKET INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) 38 38 38 ALS4-1032-225 34 34 34 34 AN3C5A BOLT 4 4 4 AN3C6A BOLT 4 4 4 AN6C44A BOLT AN8C35A BOLT 38 38 38 38 AN960C10L WASHER /F\-AN960C816L WASHER 1 1 4 4 4 MS21043-6 NUT MS21083C8 1 1 1 NUT 4 4 4 NAS1515H3L WASHER

102/02/06 12/02/06

3

DESIG	DART AEROSPACE	USA,	INC.
REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	DS	98.04.16
В	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
С	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
D	ADD HOLES AND SHACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
E	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE QZ741, GTY (2) AN960C816; REMOVE QTY (2) MS21083C8	СВ	07.05.17
F	INCORPORATE DSI 9413; DTY (3) DS37-1 WAS DTY (5) (ZN C8-1); D3791-1/-3 REPLACES DS35-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCK 08-04-3)	PH	08.07.16

DRAWN DRAWING NO. CHECKED REV. F D2750 MFG. APPR. SHEET 1 OF 11 APPROVED TITLE SCALE 350 SKIDTUBE ASSEMBLY DE APPR. NTS COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. DATE 08.07.16 THIS OCCUPIENT OF PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRISES CONDITION TO BE USED FOR ANY PARPOSE OR COMED OR COMMINICATED TO ANY OTHER PERSON FROM DAT A GROSPACE USA, INC.

**GENERAL NOTES:** 

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D

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 004

9) 10)

WELD PER DART QSI 004
INSTALL ALSA-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

FINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL F SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

PORT HADLOCK, WA

W/O:	7		WC	ORK ORDER CH	ANGES						
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval* QC Inspector	
									1.00g		
Part No	•	PAR #:	Fault Cate	gory:	NC	R: Yes	No <b>DQ</b>	A:	Date: _		
			Disposition: C				QA: N/C Closed: Date:				
NCR:		\	WORK ORD	ER NON-CONFO	RMANCE	(NCR	)				
		Description of NC	n of NC Corrective Action			Sign &	Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Section C		Chief Eng	QC Inspector		
		2									

79852

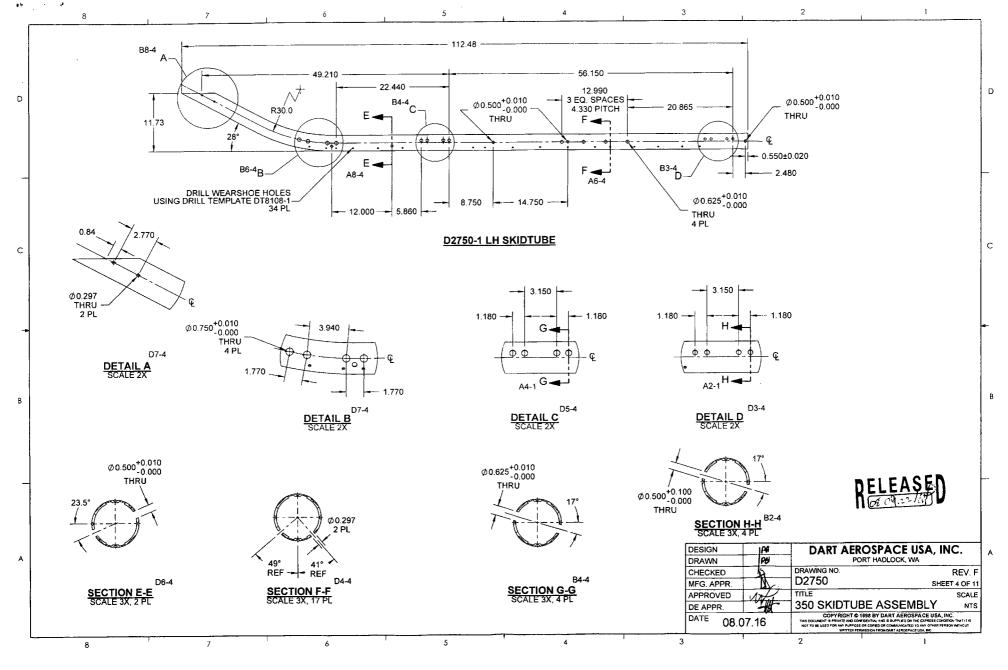
D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH

DESIGN	Pel	DART AEROSPACE USA. II	NC.
DRAWN	A	PORT HADLOCK, WA	
CHECKED	Α,	DRAWING NO.	REV. F
MFG. APPR.		D2750 <sub>SHE</sub>	ET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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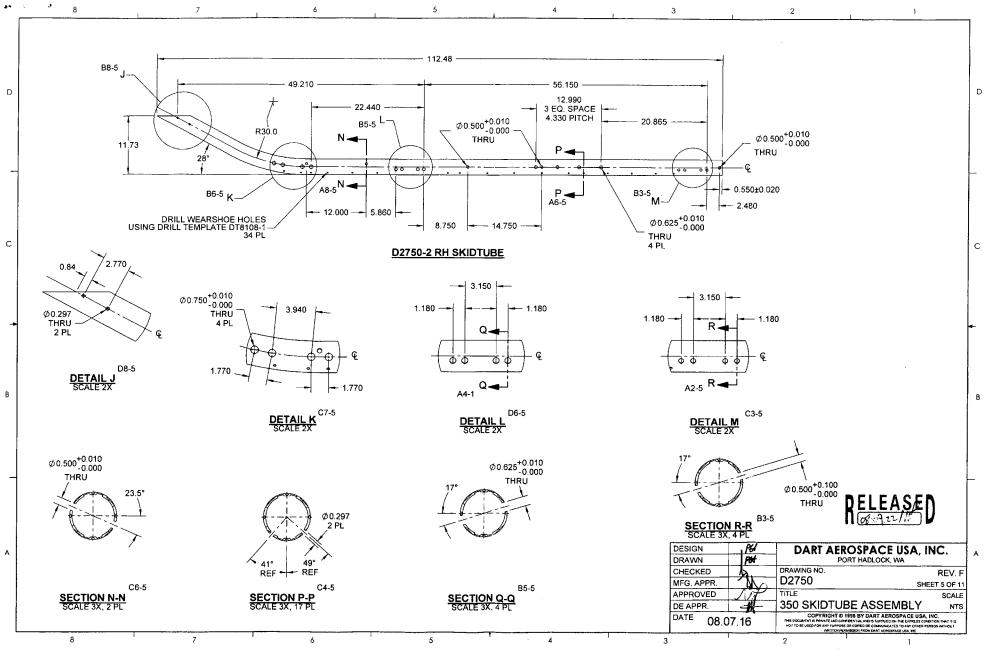
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PORT HADLOCK, WA DESIGN 100 DRAWN CHECKED DRAWING NO. REV. F D2750 MFG. APPR. SHEET 3 OF 11 APPROVED TITLE SCALE 350 SKIDTUBE ASSEMBLY DE APPR. COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
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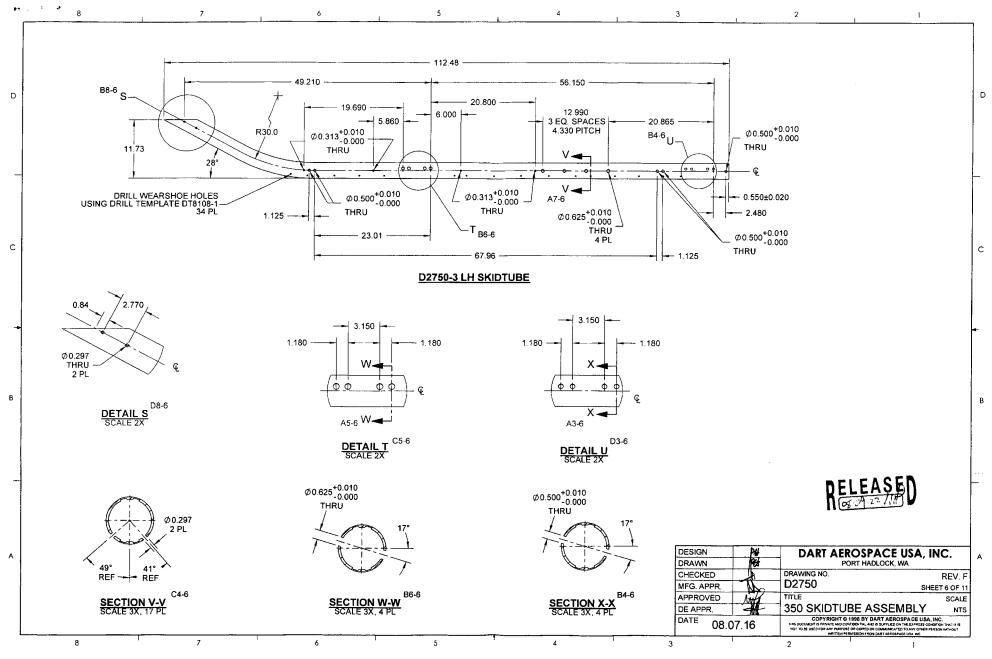


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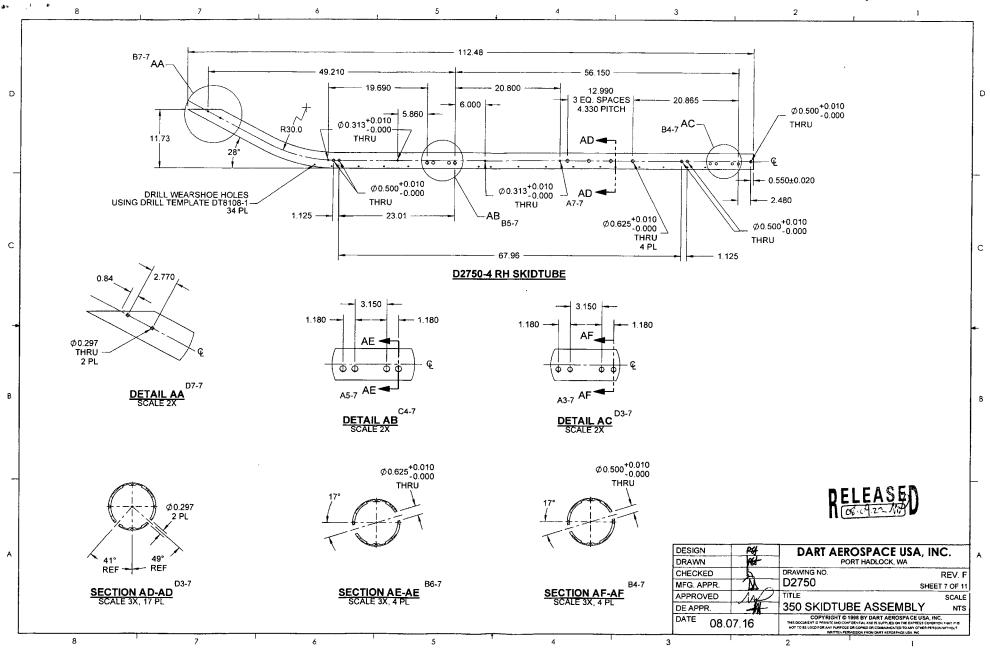
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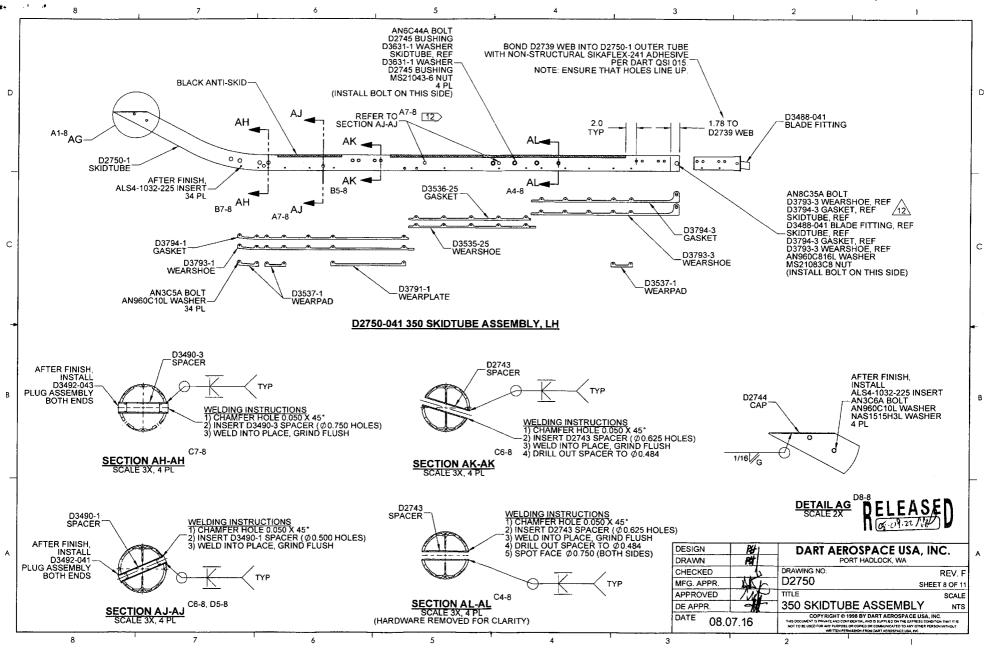
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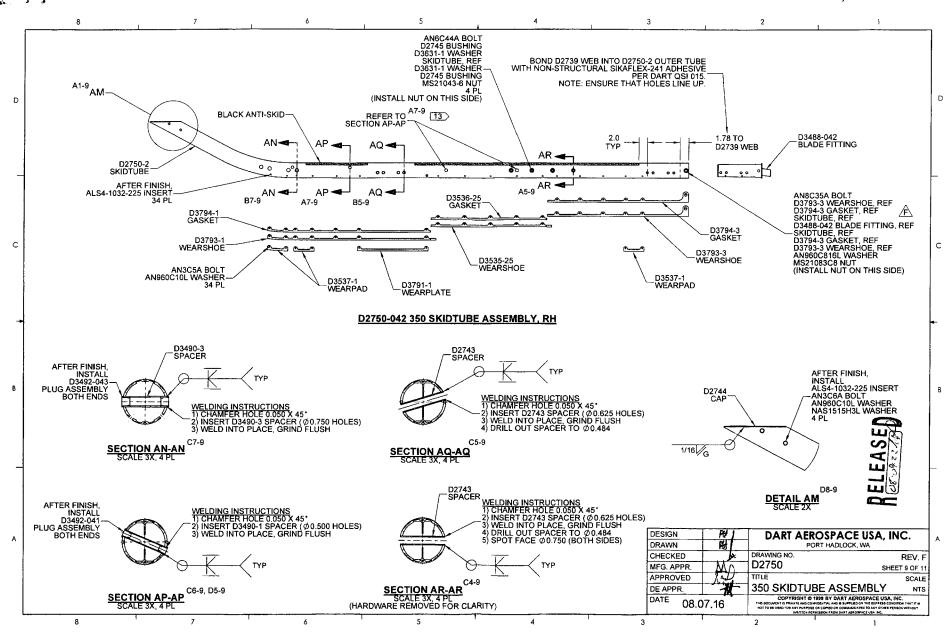
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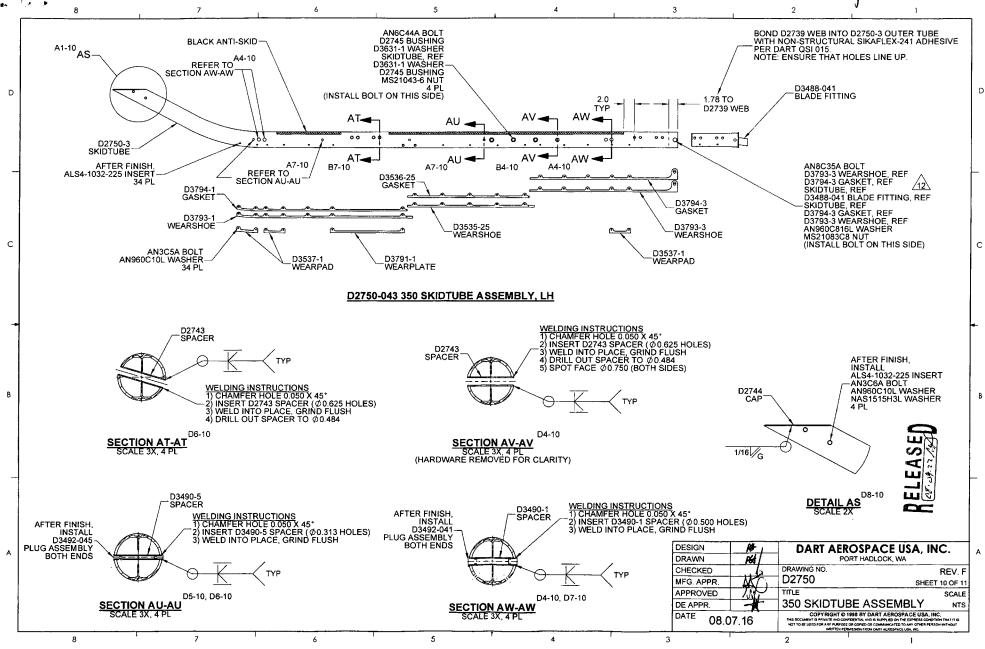
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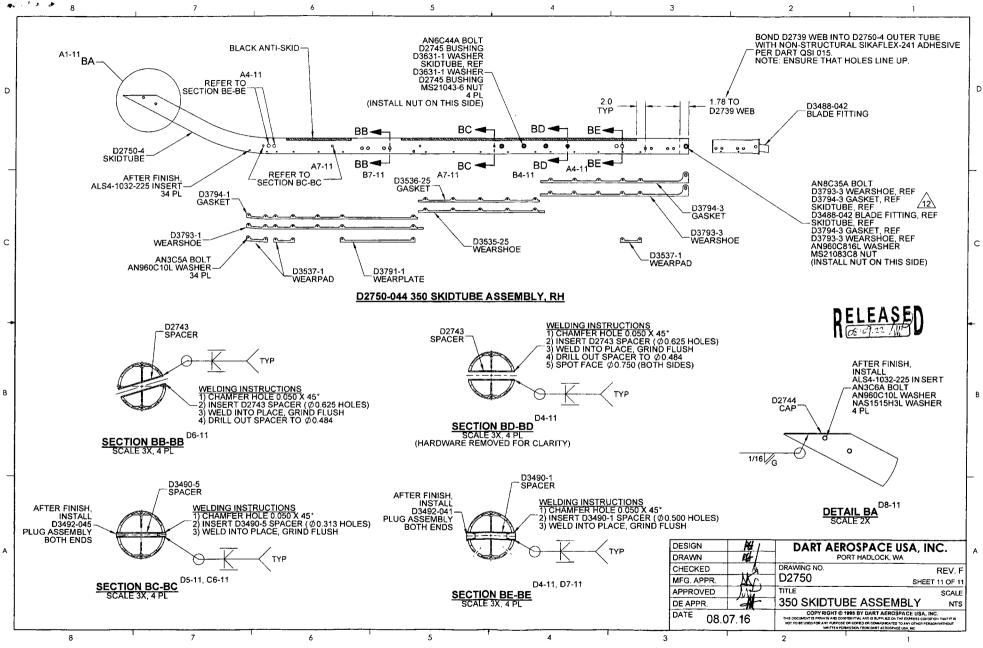


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NO. 282

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Barday Elliott

Job number:	784/3
Part number: 1350-6	36-0//
Description: Skid A	ube
Welding Process: Tig[ Mi	g[ ]
Base materiel: Alum	aum
Current: AC[ DC[ ]	
TEST	REQUIREMENTS AND RESULTS
	·
Visual:	pass[ fail[ ]
Penetration:	pass[/ fail[]
	k-m-sfs.1f 1
UNACCEPTABLE	
	,
Cracks:	pass[/] fail[]
Undercut:	pass[/] fail[ ]
Pin holes:	pass[// fail[ ]
Overlap (cold lap)	pass[ ] fail[ ]
Porosity (surface):	pass[4] fail[]
Coloration:	pass[ / fail[ ]
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Qualifier Ward Bullet	Date of Test Coupon
D 1/ 0/1/1	
Welder Borclay Cliff	Date of Test Coupon /2.03.01
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The above named individual is qualified in accordance with AWS D17.1.2001 to weld